

Date: Thursday, 4/5/2007 11:59:13 AM
User: Kim Johnston

Process Sheet

Split

07-06-28

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
 Job Number : 31694-1
 Estimate Number : 10258
 P.O. Number : *NA* Part Number : D2332041
 This Issue : 4/5/2007 S.O. No. : *NA* Drawing Number : D2332 REV C1
 Prsht Rev. : NC Project Number : N/A
 First Issue : *NA* Type : SMALL /MED FAB Drawing Revision : C1
 Previous Run : 31105 Material : *NA*
 Written By : Due Date : 5/5/2007 Qty: 20 Um: Each
 Checked & Approved By : *07.04.05*
 Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 K
 J/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR1000W049

304 RD Tube 1.0" x .049W



Comment: Qty.: 0.4368 f(s)/Unit Total : 8.7360 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch

(20) M103240 (20)

2.0

M304R250

1/4" 304 SS Roundbar



Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s)

Material: Ø0.250" 304SS Rod

Batch *DA 103111 M104128*

3.0

SMALL FAB-1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

20
(PTU)

Ph *07/06/25*

4.0

M304TR0500W035

304 RD Tube .500 x .035W



Comment: Qty.: 1.2080 f(s)/Unit Total : 24.1600 f(s)

304 RD Tube .500 x .035W

*Batch 103907**(M1046401)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-25	3.2	07/20 D2332-5 were cut to short (1.00" → 0.970") instead of 1.250" Root cause: employee did not cut to correct length and check dwg, part size	05/01/22	Scrap: replace D2332-5 : cut to 1.25" cut one and ver. by Q.C.	07/06/27	En 07/06/27 07/06/27	05/01/22	07-06-25

NOTE: Date & initial all entries

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Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 31694

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

Batch: m103987

FF 07-04-26 40

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

- Ensure to remove foreign objects.

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

A/R SS Rod Batch: M102756

07-06-27 20

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-06-27 20

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-06-27 170

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

SAP 07-06-28 19

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M101291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-28	9.0	Split w/o for a Qty 1 on the - 2 w/o. 19 remain on this w/o	J	07-06-28	19	J 07-06-28	J 07-06-28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/5/2007 11:59:13 AM
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Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 31694

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960JD416L

Washer

M104214

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS21042L4

Nut (or -4)

M102552

SAD

07/06/28

(20)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/28 (19)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SK 211

C

7/6/29

SP

(18)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/29

Job Completion



C 07/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector






Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

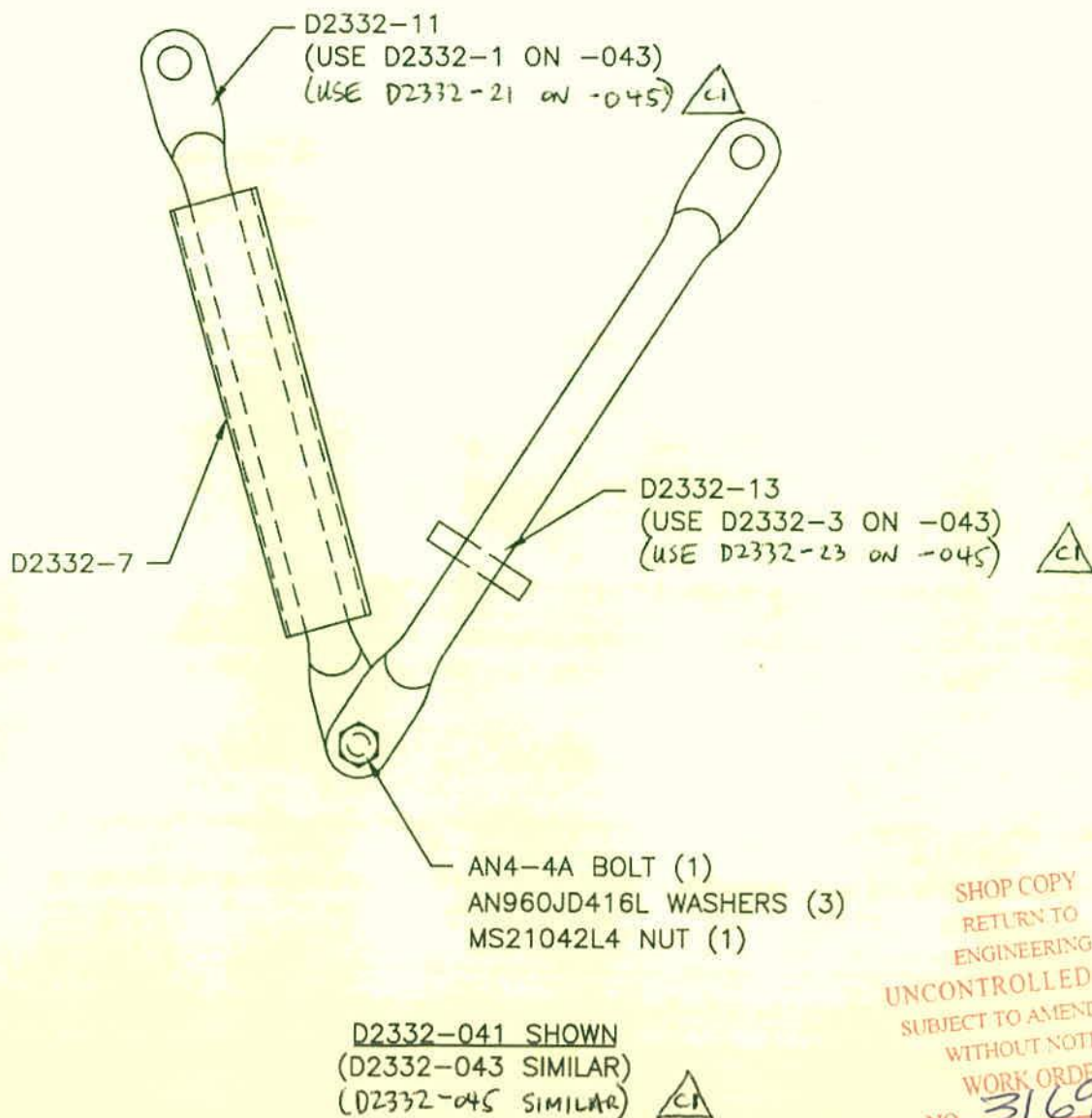
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04 *[Signature]*



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NO. *31694*

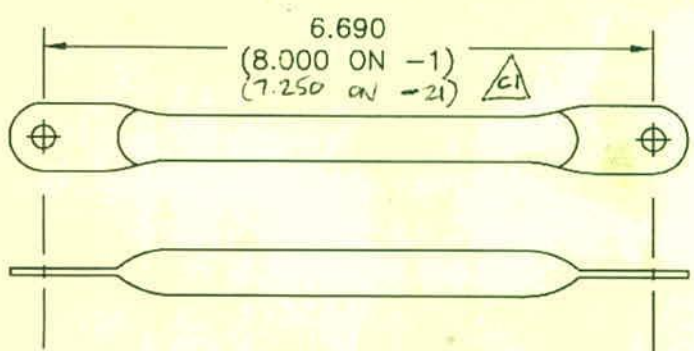
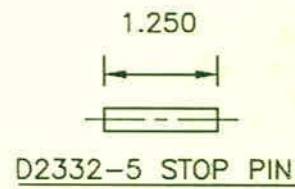
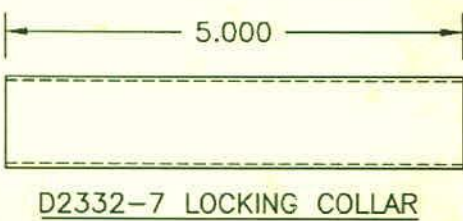
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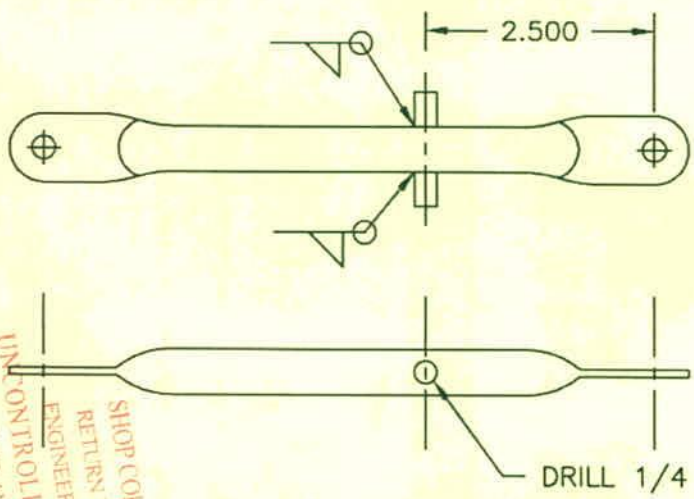


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	DATE 03.08.06	REV. C
		SHEET 2 OF 2
		SCALE 1:2

TITLE	DRAWING NO.	REV. C
LID PROP ASSEMBLY	D2332	
	MAKE -041 Prop 6.69" LONG (INT)	
	MAKE -043 Prop 8.00" LONG (INT)	
	ADD -045 Prop 7.25" LONG	



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13
M/F D2332-11 & D2332-5

{ D2332-3 SIMILAR - M/F D2332-1 & D2332-5 }
{ D2332-23 SIMILAR - M/F D2332-21 & D2332-5 }

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.01.04

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